

Date: Tuesday, 12/5/2006 8:15:41 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG ASSEMBLY 206L/407 GHW LUG
 Job Number : 29780
 Estimate Number : 10318
 P.O. Number : N/A Part Number : D2659
 This Issue : 12/5/2006 S.O. No. : N/A Drawing Number : D2659 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : A
 Previous Run : 29228 Material : N/A
 Written By : Due Date : 1/5/2007 Qty: 40 Um: Each
 Checked & Approved By : *HA 06 12 05*
 Comment : Est: D 02/09/20 Re-format; Incorporated D2657; D2658 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 29780A LUG



Comment: Sub-Component LUG

D2657 B 29780A x41

29228A x3

FL 07/03/05

(44)

2.0 29780B LUG BRACKET



Comment: Sub-Component LUG BRACKET

D2658 B 21098 x5

29780B x39*

FL 07/03/05

(44)

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2659 using location Jig DT8484
 A/R Steel Rod M101655

PD/FL

07/03/05

(44)

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

HA 07/03/06 (44)

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

HA 07/03/06 (44)

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

HA 1am

07-03-06

(44)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG ASSEMBLY 206L/407 GHW LUG

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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

(44) SD Co 7/3/13

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

(44) SD Co 7/3/13

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(44) 207103/14

Job Completion



u 5703.14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

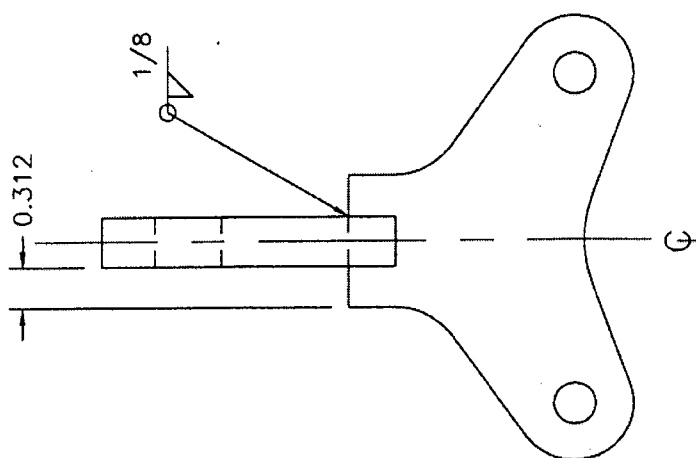
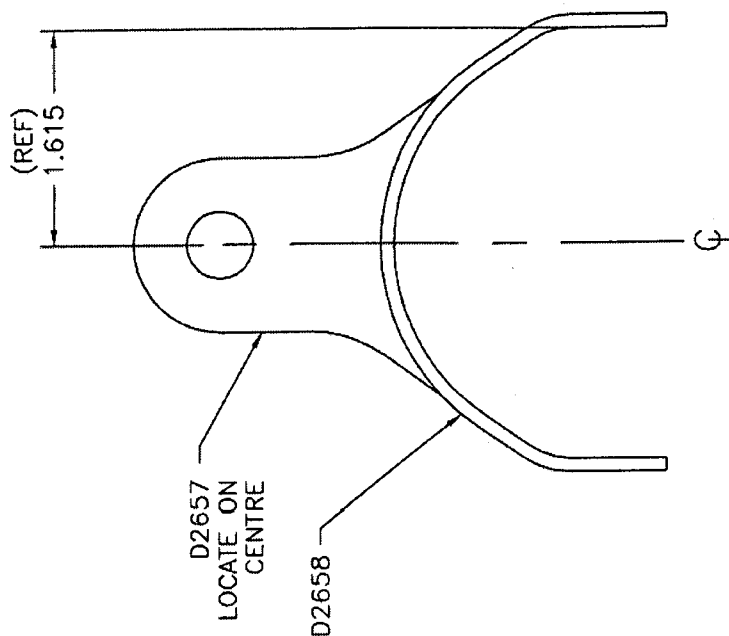
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NOTE: Date & initial all entries



DESIGN <i>DMS</i>	DRAWN BY <i>DMS</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2659	REV. A SHEET 1 OF 1
DATE 97.11.03	TITLE LUG ASSEMBLY		SCALE NTS
A	97.11.03	NEW ISSUE	

RELEASED
97/11/06 DS



D2659 LUG ASSEMBLY

WELD PER DART QSI 004
FINISH: POWDER COAT PER DART QSI 005 4.4
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTRE-LINES (C)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 29780